

Work Order ID 58944

Thursday, May 20, 2010 10:31:58 AM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 5/24/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *HL*

Date: *10-5-20*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2221

Rev H

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: *M113328*

Cpl 100603
SY 10/06/03

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Q RD 100603

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 58944

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Item ID:	D2221	Accept		Setup	Start	
Revision ID:						
Item Name:	350 Basket Base				Stop	
Start Date:	5/24/2010	Start Qty:	1.00			
Required Date:	6/4/2010	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									
130	* pressure wps4 White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat	Memo	0.00							
Powder Coating	1- Plug holes prior to								

1ST COAT:
 START TIME: 8:15 AM
 OVEN TEMPERATURE: 400°F
 FINISH TIME: 8:45 AM
 ***** 2nd coat if necessary *****
 2ND COAT:
 START TIME: 9:00 AM
 OVEN TEMPERATURE: 400°F
 FINISH TIME: 9:20 AM

Sublogles

=) 24 10/06/07

1 0

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

D BL 10-6-7

150

Identify as per dwg & Stock Location: G-A 0.00

0.00



Packaging

Memo

0.00

Packaging

w/o 58939

E/S 10/06/07 D

160

QC21- Final Inspection - Work Order Release 0.00

0.00



QC

Memo

0.00

Quality Control

10/06/08 HJ
ME
10-6-7

Dart Aerospace Ltd

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Picklist Print

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Page 1

Work Order ID: 58944

Parent Item: D2221

Parent Item Name: 350 Basket Base



Start Date: 5/24/2010

Required Date: 6/4/2010



Comments: IPP Rev:J 05-09-02 Added D3442-1 ☐ KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00



Required Qty: 1.00

✓ D2221-1 Manufactured No 100 Each 23.0000 1
 Rib   10/05/30



Location	Loc Qty	Loc Code
WA	23	
57182	1	
57499	10	
58122	12	

✓ D2221-5 Manufactured No 100 Each 16.0000 2
 Rib   10/05/30

Location	Loc Qty	Loc Code
WA	16	
57500	8	
58027	8	

✓ D2221-7 Manufactured No 100 Each 8.0000 1
 Rib   10/05/30

Location	Loc Qty	Loc Code
WA	8	
57501	4	
57805	4	

✓ D2232-3 Manufactured No 100 Each 14.0000 2
 Basket Hinge   10/05/30

Location	Loc Qty	Loc Code
WA	14	
57502	8	
57793	6	

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IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2235-1 Manufactured No 100 Each 12.0000 2



Basket Rib



B59035@ *SY* 10/05/30

Location Loc Qty Loc Code

WA 12
57593 2
57792 10

D2581 Manufactured No 100 Each 44.0000 2



Mounting Bracket



SY 10/05/30

Location Loc Qty Loc Code

WA 44
46086 2
51745 2
57185 1
58301 19
58687 20

D3442-1 Manufactured No 100 Each 28.0000 2



Shim



SY 10/05/30

Location Loc Qty Loc Code

WA 28
56579 16
58028 12

Q

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Shop Packet Print

Page 2

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IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3825-041 Manufactured No 100 Each 8.0000 2

Rib Assembly (Basket End)

Location	Loc Qty	Loc Code
WA	8	
57401	2	
58025	6	

D3826-041 Manufactured No 100 Each 8.0000 2

Rib / Gusset Assembly

Location	Loc Qty	Loc Code
WA	8	
57432	2	
57835	6	

D3827-041 Manufactured No 100 Each 10.0000 1

Rib Assembly (Inboard)

Location	Loc Qty	Loc Code
WA	10	
57219	4	
57802	6	

D3832-1 Manufactured No 100 Each 6.0000 1

Mesh (Base)

Location	Loc Qty	Loc Code
WA	6	
57791	3	
58165	3	

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Page 3

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IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

9.0000

2



Mesh (Base End Face)



Handwritten: B59184 → Q

Location

Loc Qty

Loc Code

WA

9

56396

1

57834

8

Thursday, May 20, 2010 10:32:04 AM

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Page 4

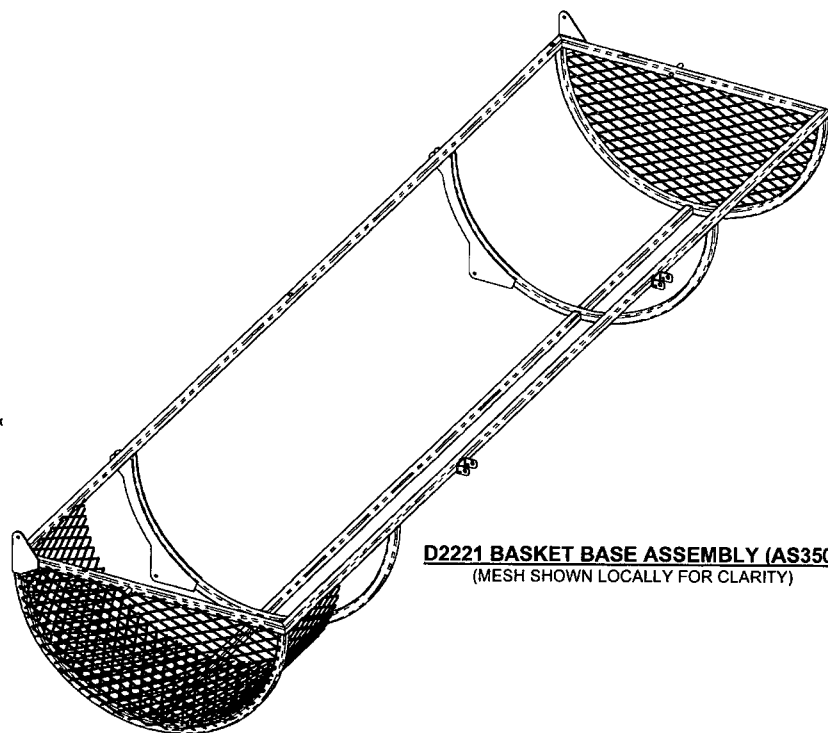
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RECEIVED
08/11/98

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58944
B1-0-5-20

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN D4-3, C2-3 AND A5-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2227-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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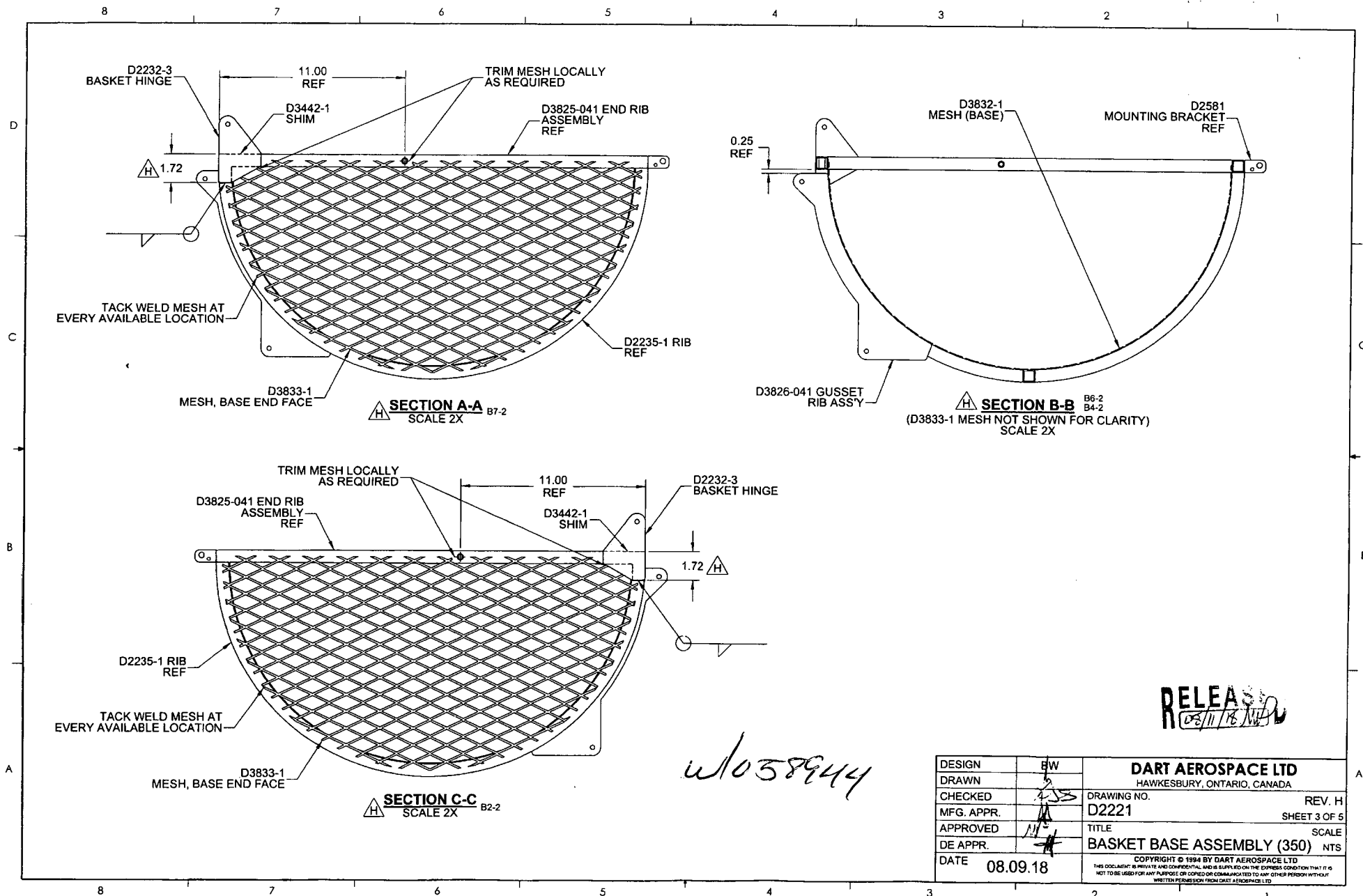
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RELEASE
03/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4.55	DRAWING NO.	REV. H
MFG. APPR.	1/1	D2221	SHEET 3 OF 5
APPROVED	1/1	TITLE	SCALE
DE APPR.	1/1	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

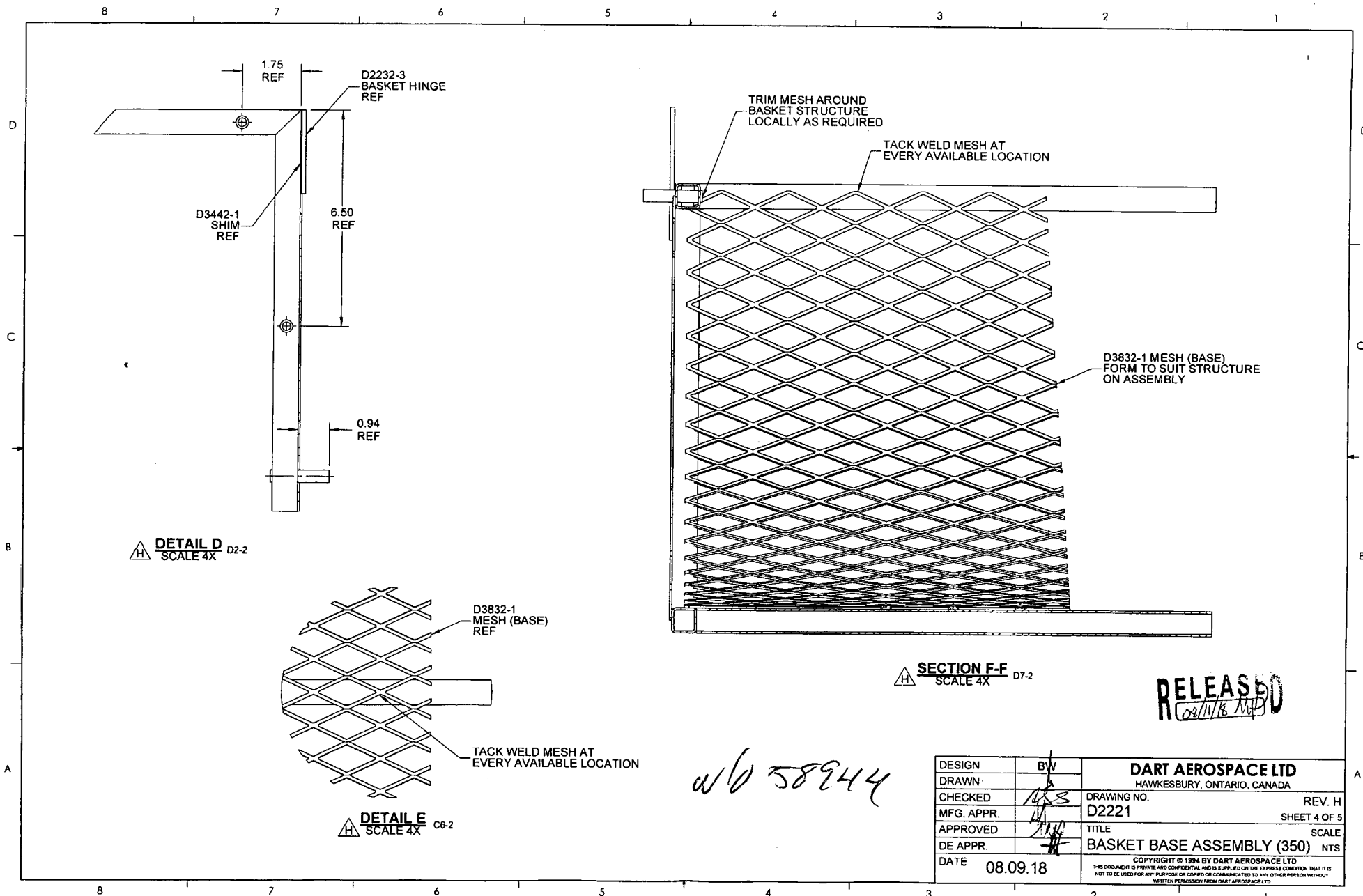
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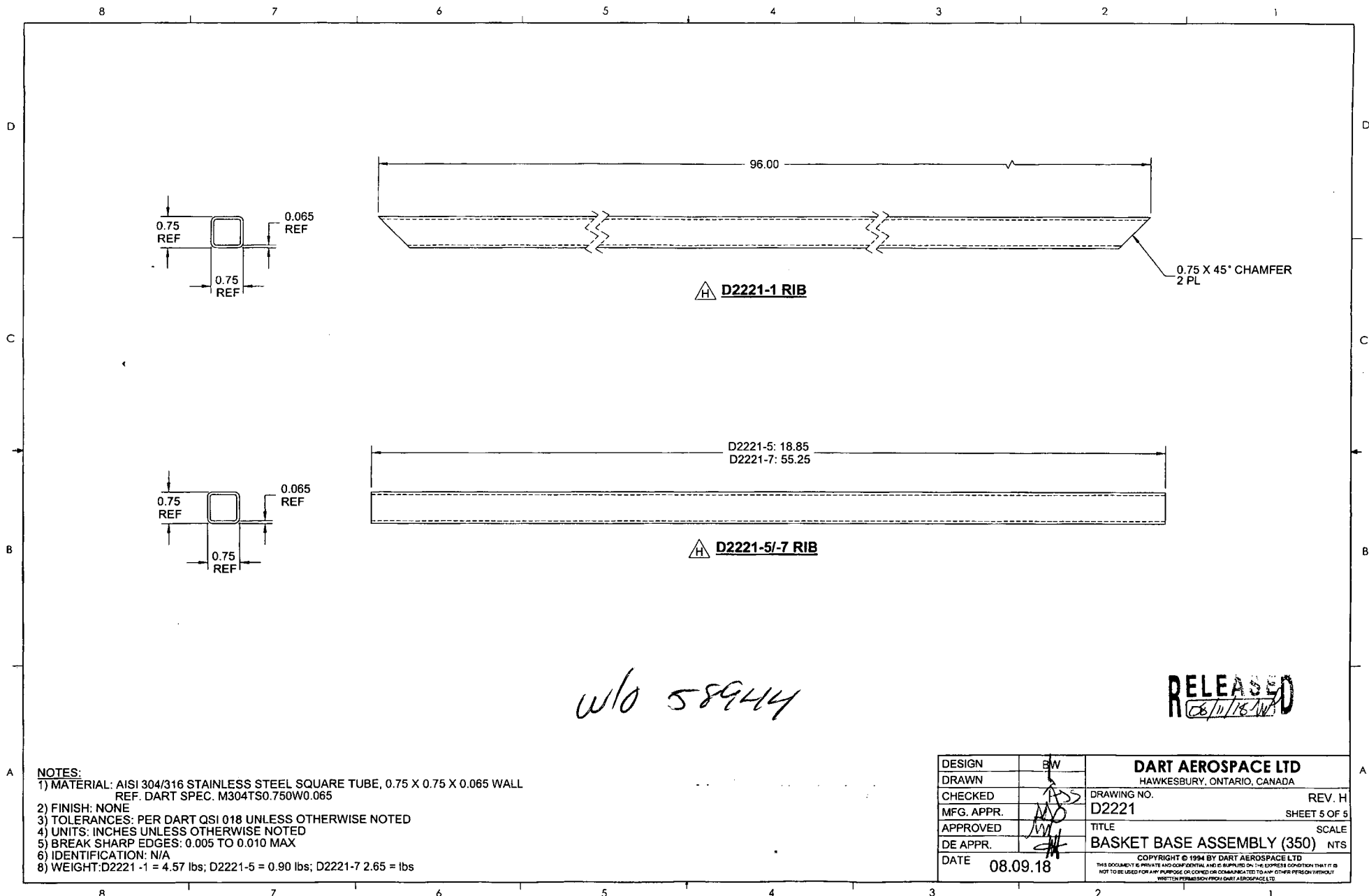
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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	AD	D2221	SHEET 5 OF 5
APPROVED	MY	TITLE	SCALE
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